



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D2666-2**  
**Job Sheet 208764**



**Part No:** D2666-2

**Job Qty:** 10 pcs

**Part Name:** Saddle, RH, Fwd, Aft, In



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 4/1/20

**Job Tracking No:**

**Due Date:** 5/11/20

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier         |           | Sign-off |
|-------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------------|-----------|----------|
|       |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier       | Lead Time |          |
| 100   | HAAS 4 Axis                 | 10 pcs | 5/9/20     |          | 1.00      | 10.00   | HAAS - 1                    |           |          |
|       |                             |        |            |          |           |         | HAAS - 2                    |           |          |
|       |                             |        |            |          |           |         | HAAS - 3                    |           |          |
|       |                             |        |            |          |           |         | HAAS - 4                    |           |          |
| 110   | Conventional Mill - 1 - B4B | 10 pcs | 5/9/20     |          | 0.00      | 1.54    | Conventional Mill - 1 - B4B |           |          |
|       |                             |        |            |          |           |         | Conventional Mill - 2 - B4B |           |          |
| 120   | QC 2                        | 10 pcs | 5/9/20     |          | 0.00      | 0.00    | QC 2 - 1                    |           |          |
|       |                             |        |            |          |           |         | QC 2 - 12                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 14                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 17                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 19                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 2                    |           |          |
|       |                             |        |            |          |           |         | QC 2 - 20                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 22                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 23                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 25                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 32                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 33                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 35                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 39                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 4                    |           |          |
|       |                             |        |            |          |           |         | QC 2 - 40                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 44                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 45                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 48                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 49                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 50                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 51                   |           |          |
|       |                             |        |            |          |           |         | QC 2 - 52                   |           |          |



**Container No:** S274448



**Part:** D2666-2

**Job No:** 208764

**Serial No/Batch:** S274448

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions:** Various STC's

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 04/29/20

|     |                               |           |        |      |      |                           |              |
|-----|-------------------------------|-----------|--------|------|------|---------------------------|--------------|
|     |                               |           |        |      |      | QC 2 - 57                 | SBL 20/04/20 |
|     |                               |           |        |      |      | QC 2 - 62                 |              |
|     |                               |           |        |      |      | QC 2 - 63                 |              |
|     |                               |           |        |      |      | QC 2 - 8                  |              |
|     |                               |           |        |      |      | QC 2 - 66                 |              |
|     |                               |           |        |      |      | QC 2 - 64                 |              |
|     |                               |           |        |      |      | QC 2 - 65                 |              |
|     |                               |           |        |      |      | QC 2 - 5                  |              |
|     |                               |           |        |      |      | QC 2 - 71                 |              |
|     |                               |           |        |      |      | QC 2 - 73                 |              |
|     |                               |           |        |      |      | QC 2 - 69                 |              |
|     |                               |           |        |      |      | QC 2 - 76                 |              |
|     |                               |           |        |      |      | QC 2 - 86                 |              |
|     |                               |           |        |      |      | QC 8 - 12                 |              |
|     |                               |           |        |      |      | QC 8 - 14                 |              |
|     |                               |           |        |      |      | QC 8 - 17                 |              |
|     |                               |           |        |      |      | QC 8 - 20                 |              |
|     |                               |           |        |      |      | QC 8 - 25                 |              |
|     |                               |           |        |      |      | QC 8 - 3                  |              |
|     |                               |           |        |      |      | QC 8 - 32                 |              |
|     |                               |           |        |      |      | QC 8 - 33                 |              |
|     |                               |           |        |      |      | QC 8 - 35                 |              |
|     |                               |           |        |      |      | QC 8 - 39                 |              |
|     |                               |           |        |      |      | QC 8 - 4                  |              |
|     |                               |           |        |      |      | QC 8 - 44                 |              |
|     |                               |           |        |      |      | QC 8 - 45                 |              |
|     |                               |           |        |      |      | QC 8 - 49                 |              |
|     |                               |           |        |      |      | QC 8 - 58                 |              |
|     |                               |           |        |      |      | QC 8 - 8                  |              |
|     |                               |           |        |      |      | QC 8 - 9                  |              |
|     |                               |           |        |      |      | QC 8 - 68                 |              |
|     |                               |           |        |      |      | QC 8 - 67                 |              |
|     |                               |           |        |      |      | QC 8 - 1 (A)              |              |
|     |                               |           |        |      |      | QC 8 - 47                 |              |
|     |                               |           |        |      |      | QC 8 - 40                 |              |
|     |                               |           |        |      |      | QC 8 - 52                 |              |
|     |                               |           |        |      |      | QC 8 - 23                 |              |
|     |                               |           |        |      |      | QC 8 - 57                 |              |
|     |                               |           |        |      |      | QC 8 - 76                 |              |
|     |                               |           |        |      |      | QC 8 - 61                 |              |
|     |                               |           |        |      |      | QC 8 - 66                 |              |
| 140 | Handfinish - 1-1 Chemical-B4B | 10<br>pcs | 5/9/20 | 0.00 | 1.18 | Handfinish - 1 - 1 - B4B  | BEL 20-05-01 |
|     |                               |           |        |      |      | Handfinish - 1 - 2 - B4B  |              |
|     |                               |           |        |      |      | Handfinish - 1 - 3 - B4B  |              |
|     |                               |           |        |      |      | Handfinish - 1 - 4 - B4B  |              |
|     |                               |           |        |      |      | Handfinish - 1 - 5 - B4B  |              |
|     |                               |           |        |      |      | Handfinish - 1 - 6 - B4B  |              |
|     |                               |           |        |      |      | Handfinish - 1 - 7 - B4B  |              |
|     |                               |           |        |      |      | Handfinish - 1 - 8 - B4B  |              |
|     |                               |           |        |      |      | Handfinish - 1 - 9 - B4B  |              |
|     |                               |           |        |      |      | Handfinish - 1 - 10 - B4B |              |
|     |                               |           |        |      |      | Handfinish - 1 - 11 - B4B |              |
|     |                               |           |        |      |      | Handfinish - 1 - 12 - B4B |              |
|     |                               |           |        |      |      | Handfinish - 1 - 13 - B4B |              |
|     |                               |           |        |      |      | Handfinish - 1 - 14 - B4B |              |

|     |                                 |        |         |                           |                        |
|-----|---------------------------------|--------|---------|---------------------------|------------------------|
|     |                                 |        |         | Handfinish - 1 - 15 - B4B |                        |
|     |                                 |        |         | Handfinish - 1 - 16 - B4B |                        |
|     |                                 |        |         | Handfinish - 1 - 17 - B4B |                        |
|     |                                 |        |         | Handfinish - 1 - 18 - B4B |                        |
|     |                                 |        |         | Handfinish - 1 - 19 - B4B |                        |
|     |                                 |        |         | Handfinish - 1 - 20 - B4B |                        |
|     |                                 |        |         | Handfinish - 1 - 21 - B4B |                        |
|     |                                 |        |         | Handfinish - 1 - 22 - B4B |                        |
| 150 | Powdercoat - 1 White Gl(A)- B4B | 10 pcs | 5/11/20 | 0.00 0.34                 | Powdercoat - 1 - B4B   |
|     |                                 |        |         |                           | Powdercoat - 2 - B4B   |
|     |                                 |        |         |                           | Powdercoat - 3 - B4B   |
|     |                                 |        |         |                           | Powdercoat - 4 - B4B   |
| 160 | QC 3                            | 10 pcs | 5/11/20 | 0.00 0.00                 | QC 3 - 10              |
|     |                                 |        |         |                           | QC 3 - 13              |
|     |                                 |        |         |                           | QC 3 - 15              |
|     |                                 |        |         |                           | QC 3 - 17              |
|     |                                 |        |         |                           | QC 3 - 18              |
|     |                                 |        |         |                           | QC 3 - 2               |
|     |                                 |        |         |                           | QC 3 - 28              |
|     |                                 |        |         |                           | QC 3 - 3               |
|     |                                 |        |         |                           | QC 3 - 30              |
|     |                                 |        |         |                           | QC 3 - 34              |
|     |                                 |        |         |                           | QC 3 - 36              |
|     |                                 |        |         |                           | QC 3 - 41              |
|     |                                 |        |         |                           | QC 3 - 51              |
|     |                                 |        |         |                           | QC 3 - 58              |
|     |                                 |        |         |                           | QC 3 - 59              |
|     |                                 |        |         |                           | QC 3 - 68              |
|     |                                 |        |         |                           | QC 3 - 9               |
|     |                                 |        |         |                           | QC 3 - 40              |
|     |                                 |        |         |                           | QC 3 - 19              |
|     |                                 |        |         |                           | QC 3 - 43              |
|     |                                 |        |         |                           | QC 3 - 24              |
|     |                                 |        |         |                           | QC 3 - 61              |
|     |                                 |        |         |                           | QC 3 - 81              |
|     |                                 |        |         |                           | QC 3 - 82              |
|     |                                 |        |         |                           | QC 3 - 87              |
| 170 | Packaging 3-1 - Stock - B4B     | 10 pcs | 5/11/20 | 0.00 0.00                 | Packaging 3 - 1 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 2 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 3 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 4 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 5 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 6 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 7 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 8 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 9 - B4B  |
|     |                                 |        |         |                           | Packaging 3 - 10 - B4B |
|     |                                 |        |         |                           | Packaging 3 - 11 - B4B |
|     |                                 |        |         |                           | Packaging 3 - 12 - B4B |
|     |                                 |        |         |                           | Packaging 3 - 13 - B4B |
|     |                                 |        |         |                           | Packaging 3 - 14 - B4B |
|     |                                 |        |         |                           | Packaging 3 - 15 - B4B |

|                |           |         |           |                        |                |
|----------------|-----------|---------|-----------|------------------------|----------------|
|                |           |         |           | Packaging 3 - 16 - B4B |                |
|                |           |         |           | Packaging 3 - 17 - B4B |                |
|                |           |         |           | Packaging 3 - 18 - B4B |                |
|                |           |         |           | Packaging 3 - 19 - B4B |                |
|                |           |         |           | Packaging 3 - 20 - B4B |                |
|                |           |         |           | Packaging 3 - 21 - B4B |                |
|                |           |         |           | Packaging 3 - 22 - B4B |                |
|                |           |         |           | Packaging 3 - 23 - B4B |                |
|                |           |         |           | Packaging 3 - 24 - B4B |                |
|                |           |         |           | Packaging 3 - 25 - B4B |                |
|                |           |         |           | Packaging 3 - 26 - B4B |                |
|                |           |         |           | Packaging 3 - 27 - B4B |                |
|                |           |         |           | Packaging 3 - 28 - B4B |                |
|                |           |         |           | Packaging 3 - 29 - B4B |                |
|                |           |         |           | Packaging 3 - 30 - B4B |                |
|                |           |         |           | Packaging 3 - 31 - B4B |                |
|                |           |         |           | Packaging 3 - 32 - B4B |                |
|                |           |         |           | Packaging 3 - 33 - B4B |                |
|                |           |         |           | Packaging 3 - 34 - B4B |                |
|                |           |         |           | Packaging 3 - 35 - B4B |                |
|                |           |         |           | Packaging 3 - 36 - B4B |                |
|                |           |         |           | Packaging 3 - 37 - B4B |                |
| 180 QC 21 - SA | 10<br>pcs | 5/11/20 | 0.00 0.00 | QC 21 - SA - 21        | DAS            |
|                |           |         |           | QC 21 - SA - 70        | MAY 05 2020 70 |
|                |           |         |           | QC 21 - SA - 53        | 9-89           |

Part Op **100** - HAAS CNC Vertical Machine - Program batch number. 1-Inspect part number and batch number are programmed  
 Descriptions: correctly. 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of  
 Folio and visually inspect as per attached Dimension Sheet 6  
**110** - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet  
**120** - QC2- Inspect parts off machine FAI/FAIB  
**130** - QC8- Inspect parts - second check  
**140** - Chemical Conversion Coat per QSI005 4.1  
**150** - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: \_\_\_\_\_  
**160** - QC3- Inspect Part Finish  
**170** - Identify as per dwg & Stock Location: \_\_\_\_\_  
**180** - QC21- Final Inspection - Work Order Release

| Job BOM     |                |               |                 |           |
|-------------|----------------|---------------|-----------------|-----------|
| Part / Item | Component Name | Quantity      | Operation       | Container |
| D6101-001   | Saddle Billet  | 10 pcs (1 ea) | 100-HAAS 4 Axis | S212953   |

| Job Allocations |                |          |           |           |
|-----------------|----------------|----------|-----------|-----------|
| Operation       | Component Part | Required | Inventory | Allocated |
| 100-HAAS 4 Axis | D6101-001      | 10       | 32        | 0         |

| Part Specifications                |
|------------------------------------|
| Specifications could not be found. |

Plex 4/1/20 8:16 AM Dart.lajeunesse.marie

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|                                                                    |  |                     |         |
|--------------------------------------------------------------------|--|---------------------|---------|
| <b>DART AEROSPACE LTD</b>                                          |  | <b>Work Order:</b>  | 208751  |
| <b>Description:</b> 206 Saddle, Inboard, Right side                |  | <b>Part Number:</b> | D2666-2 |
| <b>Inspection Dwg:</b> D2666 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b> |  | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim           | Min   | Max   | Go/No Go Gauge | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
|               |       |       |                | 1                        | 2     | 3     | 4     | 5     |
| A             | 0.100 | 0.140 |                | 0.124                    | 0.122 | 0.122 | 0.121 | 0.121 |
| B             | 0.100 | 0.140 |                | 0.128                    | 0.128 | 0.129 | 0.130 | 0.129 |
| C             | 2.470 | 2.510 |                | 2.495                    | 2.494 | 2.494 | 2.494 | 2.494 |
| D             | 0.100 | 0.180 |                | 0.135                    | 0.135 | 0.135 | 0.135 | 0.135 |
| E             | 0.210 | 0.230 |                | 0.224                    | 0.222 | 0.223 | 0.222 | 0.222 |
| F             | 1.313 | 1.343 |                | 1.324                    | 1.324 | 1.324 | 1.324 | 1.323 |
| G             | 0.240 | 0.260 |                | 0.252                    | 0.251 | 0.252 | 0.254 | 0.254 |
| H             | 0.615 | 0.685 |                | 0.665                    | 0.660 | 0.660 | 0.660 | 0.660 |
| I             | 1.125 | 1.145 |                | 1.135                    | 1.135 | 1.135 | 1.135 | 1.135 |
| J             | 0.990 | 1.010 |                | 1.004                    | 1.004 | 1.004 | 1.004 | 1.004 |
| K             | 0.235 | 0.240 |                | 0.239                    | 0.239 | 0.239 | 0.239 | 0.239 |
| L             | 0.510 | 0.515 |                | 0.511                    | 0.511 | 0.511 | 0.511 | 0.511 |
| M             | 0.100 | 0.120 |                | 0.110                    | 0.110 | 0.110 | 0.110 | 0.110 |
| N             | 1.565 | 1.585 |                | 1.575                    | 1.575 | 1.575 | 1.575 | 1.575 |
| O             | 5.990 | 6.010 |                | 6.000                    | 6.001 | 6.001 | 6.000 | 6.002 |
| P             | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 | 1.250 |
| Q             | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 | 2.500 |
| R             | 0.490 | 0.510 |                | 0.500                    | 0.498 | 0.499 | 0.501 | 0.500 |
| S             | 0.312 | 0.318 |                | 0.313                    | 0.313 | 0.313 | 0.313 | 0.313 |
| T             | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 | 2.500 |
| U             | 1.357 | 1.367 |                | 1.362                    | 1.362 | 1.362 | 1.362 | 1.362 |
| V             | 0.315 | 0.322 |                | 0.316                    | 0.316 | 0.316 | 0.316 | 0.316 |
| W             | 0.540 | 0.560 |                | 0.550                    | 0.549 | 0.549 | 0.550 | 0.549 |
| X             | 1.674 | 1.684 |                | 1.679                    | 1.679 | 1.679 | 1.679 | 1.679 |
| Y             | 0.256 | 0.262 |                | 0.258                    | 0.258 | 0.258 | 0.258 | 0.258 |
| Z             | 0.178 | 0.198 |                | 0.188                    | 0.188 | 0.188 | 0.188 | 0.188 |
| AA            |       |       |                |                          |       |       |       |       |
| AB            |       |       |                |                          |       |       |       |       |
| AC            |       |       |                |                          |       |       |       |       |
| AD            |       |       |                |                          |       |       |       |       |
| AE            |       |       |                |                          |       |       |       |       |
| Accept/Reject |       |       |                |                          |       |       |       |       |

|                             |                       |
|-----------------------------|-----------------------|
| <b>Measured by:</b> DAP/SBL | <b>Date:</b> 20/04/30 |
| <b>Audited by:</b> MML      | <b>Date:</b> 20/05/03 |
| <b>Prototype Approval:</b>  | <b>Date:</b>          |

| Rev | Date     | Change                                                 | Revised by | Approved |
|-----|----------|--------------------------------------------------------|------------|----------|
| A   |          | New Issue                                              | RF         |          |
| B   | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A      | RF         |          |
| C   | 99.11.10 | Added Dim. R-T                                         | RF         |          |
| D   | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF      |          |
| E   | 06.06.30 | Dimension revised per drawing revision C               | KJ/JLM     |          |
| F   | 07.03.21 | Revised per drawing revision D                         | KJ/JLM     |          |
| G   | 12.03.08 | Dimension S and Y revised                              | KJ         | M        |

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|                                                     |               |                                            |
|-----------------------------------------------------|---------------|--------------------------------------------|
| <b>DART AEROSPACE LTD</b>                           |               | <b>Work Order:</b> 208751                  |
| <b>Description:</b> 206 Saddle, Inboard, Right side |               | <b>Part Number:</b> D2666-2                |
| <b>Inspection Dwg:</b> D2666                        | <b>Rev:</b> D | <b>DSK:</b> <b>Rev:</b> <b>Page 1 of 1</b> |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim           | Min   | Max   | Go/No Go Gauge | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
|               |       |       |                | 6                        | 7     | 8     | 9     | 10    |
| A             | 0.100 | 0.140 |                | 0.123                    | 0.123 | 0.122 | 0.122 | 0.122 |
| B             | 0.100 | 0.140 |                | 0.130                    | 0.129 | 0.130 | 0.130 | 0.129 |
| C             | 2.470 | 2.510 |                | 2.494                    | 2.494 | 2.495 | 2.494 | 2.494 |
| D             | 0.100 | 0.180 |                | 0.133                    | 0.135 | 0.135 | 0.135 | 0.135 |
| E             | 0.210 | 0.230 |                | 0.223                    | 0.223 | 0.223 | 0.223 | 0.223 |
| F             | 1.313 | 1.343 |                | 1.325                    | 1.325 | 1.324 | 1.324 | 1.324 |
| G             | 0.240 | 0.260 |                | 0.255                    | 0.254 | 0.254 | 0.254 | 0.255 |
| H             | 0.615 | 0.685 |                | 0.660                    | 0.660 | 0.660 | 0.660 | 0.660 |
| I             | 1.125 | 1.145 |                | 1.135                    | 1.135 | 1.135 | 1.135 | 1.135 |
| J             | 0.990 | 1.010 |                | 1.004                    | 1.004 | 1.005 | 1.004 | 1.004 |
| K             | 0.235 | 0.240 |                | 0.239                    | 0.238 | 0.239 | 0.239 | 0.239 |
| L             | 0.510 | 0.515 |                | 0.511                    | 0.511 | 0.511 | 0.511 | 0.511 |
| M             | 0.100 | 0.120 |                | 0.110                    | 0.110 | 0.110 | 0.110 | 0.110 |
| N             | 1.565 | 1.585 |                | 1.575                    | 1.575 | 1.575 | 1.575 | 1.575 |
| O             | 5.990 | 6.010 |                | 6.002                    | 6.002 | 6.002 | 6.002 | 6.002 |
| P             | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 | 1.250 |
| Q             | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 | 2.500 |
| R             | 0.490 | 0.510 |                | 0.500                    | 0.499 | 0.490 | 0.497 | 0.500 |
| S             | 0.312 | 0.318 |                | 0.313                    | 0.313 | 0.313 | 0.313 | 0.313 |
| T             | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 | 2.500 |
| U             | 1.357 | 1.367 |                | 1.362                    | 1.362 | 1.362 | 1.362 | 1.362 |
| V             | 0.315 | 0.322 |                | 0.316                    | 0.316 | 0.316 | 0.316 | 0.316 |
| W             | 0.540 | 0.560 |                | 0.549                    | 0.549 | 0.550 | 0.549 | 0.549 |
| X             | 1.674 | 1.684 |                | 1.679                    | 1.679 | 1.679 | 1.679 | 1.679 |
| Y             | 0.256 | 0.262 |                | 0.258                    | 0.258 | 0.258 | 0.258 | 0.258 |
| Z             | 0.178 | 0.198 |                | 0.188                    | 0.188 | 0.188 | 0.188 | 0.188 |
| AA            |       |       |                |                          |       |       |       |       |
| AB            |       |       |                |                          |       |       |       |       |
| AC            |       |       |                |                          |       |       |       |       |
| AD            |       |       |                |                          |       |       |       |       |
| AE            |       |       |                |                          |       |       |       |       |
| Accept/Reject |       |       |                |                          |       |       |       |       |

|                            |                       |
|----------------------------|-----------------------|
| <b>Measured by:</b> SBC    | <b>Date:</b> 20/04/30 |
| <b>Audited by:</b> JML     | <b>Date:</b> 20/05/03 |
| <b>Prototype Approval:</b> | <b>Date:</b>          |

| Rev | Date     | Change                                                 | Revised by | Approved |
|-----|----------|--------------------------------------------------------|------------|----------|
| A   |          | New Issue                                              | RF         |          |
| B   | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A      | RF         |          |
| C   | 99.11.10 | Added Dim. R-T                                         | RF         |          |
| D   | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF      |          |
| E   | 06.06.30 | Dimension revised per drawing revision C               | KJ/JLM     |          |
| F   | 07.03.21 | Revised per drawing revision D                         | KJ/JLM     |          |
| G   | 12.03.08 | Dimension S and Y revised                              | KJ         | M        |



Date:

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



|                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|-----------------|---------------|-------------------|------------------|---------|-----------------------|---------------|-------------------|----------|-----------|-----------------|---------|--------|----------------------|------|--------|------------------------------|---------------------------------|--------------------|-------------------|---------------|-------------|-----------------|---------|------------|--------------|----------------|--|
| Job: _____<br>Part No. _____                                                                                                                                                                                                                                                                                                                                                        |                                 | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                   | <b>DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/> Cross tube <input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/> Engineering <input type="checkbox"/><br>Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Water Jet <input type="checkbox"/><br>Large Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                              | Sequence #:                     | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                   | MRB (QS1042)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                    |                                 | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                   | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
|                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                   | Lead hand / Supervisor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
|                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                   | QC / QA Coordinator                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
|                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| <b>Root Cause</b><br>Operator <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |                                 | <b>FAULT CATEGORY</b><br><table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/ Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  | Pressure/Forced | Contamination | Power Loss/ Surge | Positioned Wrong | Bending | Misaligned/off center | Folio/Program | Outside Tolerance | Crushing | BOM/Route | Grain Direction | Drawing | Cracks | Broken/Damage/Defect | Weld | Finish | Crimp/Kink/Ripple/Wave/Twist | Incomplete/Unclear Instructions | Wrong Stock Pulled | Part Lost/Missing | Marks/Chatter | Drill Holes | Out of Sequence | Misread | Mislabeled | Fit/Function | Off-set/Set-up |  |
| Pressure/Forced                                                                                                                                                                                                                                                                                                                                                                     | Contamination                   | Power Loss/ Surge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Positioned Wrong  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Bending                                                                                                                                                                                                                                                                                                                                                                             | Misaligned/off center           | Folio/Program                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Outside Tolerance |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Crushing                                                                                                                                                                                                                                                                                                                                                                            | BOM/Route                       | Grain Direction                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Drawing           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Cracks                                                                                                                                                                                                                                                                                                                                                                              | Broken/Damage/Defect            | Weld                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Finish            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Crimp/Kink/Ripple/Wave/Twist                                                                                                                                                                                                                                                                                                                                                        | Incomplete/Unclear Instructions | Wrong Stock Pulled                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Part Lost/Missing |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Marks/Chatter                                                                                                                                                                                                                                                                                                                                                                       | Drill Holes                     | Out of Sequence                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Misread           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Mislabeled                                                                                                                                                                                                                                                                                                                                                                          | Fit/Function                    | Off-set/Set-up                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                      |                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                 |               |                   |                  |         |                       |               |                   |          |           |                 |         |        |                      |      |        |                              |                                 |                    |                   |               |             |                 |         |            |              |                |  |

Entered: \_\_\_\_\_

Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                           |  |                     |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------|--|---------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  | <b>DISPOSITION</b><br><div style="display: flex; justify-content: space-between;"> <div>           Rework <input type="checkbox"/><br/>           Scrap <input type="checkbox"/><br/>           Use-as-is <input type="checkbox"/> </div> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div> |  | <b>DEPARTMENT/PROCESS</b> |  | <b>MRB (QS1042)</b> |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | Sequence #: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  | QTY Affected : _____      |  |                     |  |
| <b>Description Work Order Deviation</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  | <b>Disposition</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |                           |  |                     |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                           |  |                     |  |
| <b>Root Cause</b><br><div style="display: flex; justify-content: space-between;"> <div>           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Preservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div>           Pressure/Forced <input type="checkbox"/><br/>           Bending <input type="checkbox"/><br/>           Crushing <input type="checkbox"/><br/>           Cracks <input type="checkbox"/><br/>           Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br/>           Marks/Chatter <input type="checkbox"/><br/>           Mislabeled <input type="checkbox"/> </div> <div>           Contamination <input type="checkbox"/><br/>           Misaligned/off center <input type="checkbox"/><br/>           BOM/Route <input type="checkbox"/><br/>           Broken/Damage/Defect <input type="checkbox"/><br/>           Incomplete/Unclear Instructions <input type="checkbox"/><br/>           Drill Holes <input type="checkbox"/><br/>           Fit/Function <input type="checkbox"/> </div> <div>           Power Loss/Surge <input type="checkbox"/><br/>           Folio/Program <input type="checkbox"/><br/>           Grain Direction <input type="checkbox"/><br/>           Weld <input type="checkbox"/><br/>           Wrong Stock Pulled <input type="checkbox"/><br/>           Out of Sequence <input type="checkbox"/><br/>           Off-set/Set-up <input type="checkbox"/> </div> <div>           Positioned Wrong <input type="checkbox"/><br/>           Outside Tolerance <input type="checkbox"/><br/>           Drawing <input type="checkbox"/><br/>           Finish <input type="checkbox"/><br/>           Part Lost/Missing <input type="checkbox"/><br/>           Misread <input type="checkbox"/> </div> </div> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                           |  |                     |  |
| <b>Completed By</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | <b>Lead hand / Supervisor</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                           |  |                     |  |
| <b>QC / QA Coordinator</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | <b>Other/Details:</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |                           |  |                     |  |